

Work Order ID 67760

Wednesday, March 30, 2011 10:33:33 AM



Page 1

Item ID:	D2651-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Plug					
Start Date:	3/30/2011	Start Qty:	120.00		Cust Item ID:	
Required Date:	4/4/2011	Req'd Qty:	120.00		Customer:	
Reference:						

Approvals:	Process Plan:	<i>H</i>	Date:	<i>11-03-30</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2651	Rev B								

100	Hardinge CNC LATHE SMALL	0.00							
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1- Turn as per Folio FA219 and Dwg D2651 2- Deburr								

11-4-14 *122*

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

11-4-14 *122*

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

11/04/14 *122* *0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67760

Wednesday, March 30, 2011 10:33:33 AM



Page 2

Item ID: D2651-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug

Start Date: 3/30/2011 Start Qty: 120.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 120.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr ias per dwg D2651								
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

122 ϕ All u/ok 15

150



Powder coat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

(Only larger section necessary) START TIME:

320 \square OVEN TEMPERATURE: 11:00

TIME: 11:30

FINISH

122 BL u-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67760

Wednesday, March 30, 2011 10:33:33 AM

Page 3

Item ID: D2651-1

Accept

Revision ID:

Item Name: Plug

Start Date: 3/30/2011 Start Qty: 120.00

Required Date: 4/4/2011 Req'd Qty: 120.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation

Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

u

QC3- Inspect Part Finish

~~QC3- Inspect Part Finish~~

Memo

0.00

0.00

122 0 21 4/05/02

170



Packaging

Packaging

Identify as per dwg & Stock Location: FP-A

Memo

0.00

0.00

122 0 21 4/05/02

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/5/30
11-05-3
(122)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 10:33:39 AM

Work Order ID: 67760



Parent Item: D2651-1



Parent Item Name: Plug

Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP: A 02.04.15 New Issue NG
IPP: B 05.12.12 added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6R0.500

Purchased

No

100

f

4.6050

0.0401

5.065263



11-4-14

6061-T6 Round Bar .500"

Location

Loc Qty

Loc Code

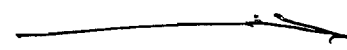
MAT012

4.605

114488

4.605

*m 117379
(not pulled)*



5.416'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

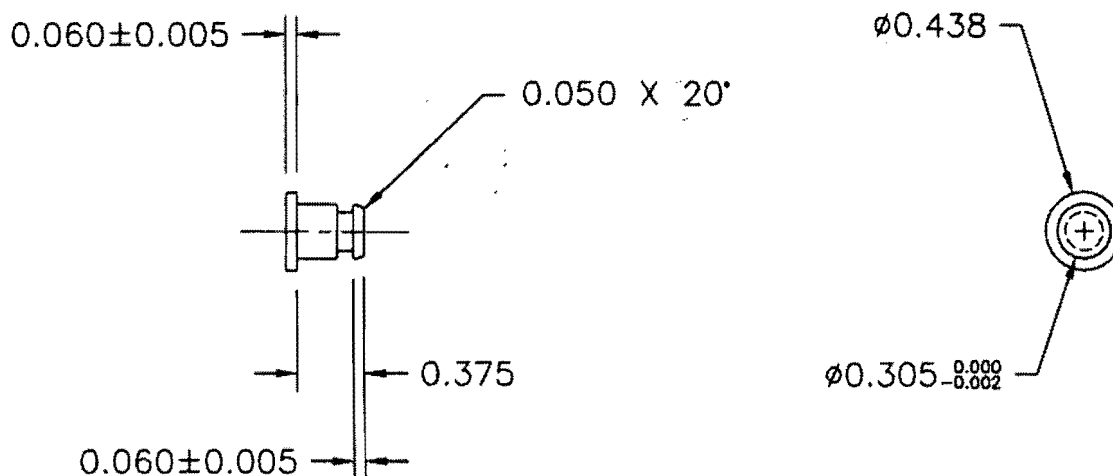
NOTE: Date & initial all entries



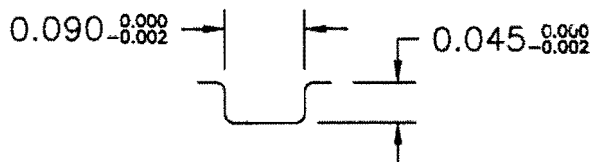
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED
03.12.19 #

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 6-1746

11-03-3C

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

Copyright © 1997 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries